

Date: Tuesday, 4/17/2007 3:54:04 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/355 AS X-TUBE AFT
Job Number : 31909	
Estimate Number : 12486	
P.O. Number : <i>N/A</i>	Part Number : D350748201
This Issue : 4/17/2007	Drawing Number : <i>N/A</i>
S.O. No. : <i>N/A</i>	Project Number : <i>N/A</i>
Prsht Rev. : NC	Drawing Revision : <i>N/A</i>
First Issue : <i>N/A</i>	Material : <i>N/A</i>
Type : LANDING GEAR	Due Date : 5/30/2007
Previous Run : 31908	Qty: 1 Um: Each
Written By : <i>[Signature]</i>	
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-07-05 JLM	
Est Rev: B Update qty of MS21042L5 06-09-12 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001 *en* *KJ 07.05.10* *(1)*

2.0	31909A	X-TUBE AS 350/355 HI AFT UNDER REVIEW
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Comment: Sub-Component X-TUBE AS 350/355 HI AFT
 D350-748-241 B *31909A* *[Signature]*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 350 SADDLE
 Batch: *B 31076* *[Signature]*

5.0	D35011	BUSHING
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
 BUSHING
 Batch: *B 28478* *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 31909

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M105057

PC

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M102552

PC

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850

PC

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M104215

PC

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M103694

PC

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M104248

PC

12.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104547

PC 7/8/30 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 2/6/8130
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 31909

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



2008.300

Comment: INSPECT 100% KITS FOR COMPLETENESS

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: _____

PPP Rev: A

CP 2007/08/300

SP

15.0

QC21

FINAL INSPECTION/W/O RELEASE



1

Comment: FINAL INSPECTION/W/O RELEASE

2007/08/30

Job Completion



2008.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE AS 350/355 HI AFT UNDER REVIEW
Job Number : 31909A	
Estimate Number : 12483	
P.O. Number : <i>N/A</i>	Part Number : D350748241
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D350-748-241 <i>HR</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>SD</i> <i>07.04.18</i>
Previous Run : 31908A	Material : <i>N/A</i>
Written By : _____	Due Date : 5/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>07.04.18</i>	
Comment : Est Rev: A New Issue 06-07-05 JLM	
Est Rev: B Update cadplate process 06-09-12 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-241 CHG001

NA
07.04.18

2.0	D6018125	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD X 2.000" ID

Batch: *B27472*

07.04.18

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

07.04.18

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

MB 07.04.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31909A

Part Number: D350748241

- Job Number:



Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241

MS 07/04/27

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/04/27

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SC 07-04-30

(2)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

JD 7-4-30

9.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3777

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

CL 07/05/15 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

Eff 07/06/04

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

JD 07 04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31909A

Part Number: D350748241

- Job Number:



Seq. #:

Machine Or Operation:

Description :

12 0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Oil inside of tube with LPS-3.

A/R

LPS-3

Batch:

M104161

SA/EL

070709

13 0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

SA/EL 070709 1

14 0

QC6

DIMENSIONAL CHECK

QC15



Comment: DIMENSIONAL CHECK

SA/EL 070711

15 0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,

Set-up drill table as per QSI 010

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241

DP

7-7-16

SA

070711

1

16 0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SA/EL 070717

17 0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4203

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C 20710718 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31909A

Part Number: D350748241

- Job Number:



Seq. #: Machine Or Operation: Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/8/17

SB

(X)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/17 (2)

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

ml 01 08 19
PT 07 08 22

(1)

21.0

QC14

INSPECT SPRAY PAINT



ml 01 08 23



(1)

Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

22.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: 28476

ml 01 08 23

23.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 32020

ml 01 08 23

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 19393

ml 01 08 23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31909A

Part Number: D350748241

Job Number:



Seq. #: Machine Or Operation: Description :

25.0 AN960JD10 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 100151

ml 01 08 23

26.0 MS2192020 Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 104902

ml 01 08 23

27.0 MS27039110 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

ml 01 08 23

28.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

ml 01 08 23

29.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 01/08/23

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: _____

PPP Rev: _____

PPR 31909

Er 01/08/30 @ SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/09/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:54:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31909A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/30

Job Completion



U 27-08-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31909A
Description: Crosstube Assembly (AS350/355 High Aft)	Part Number:	D350-748-241
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

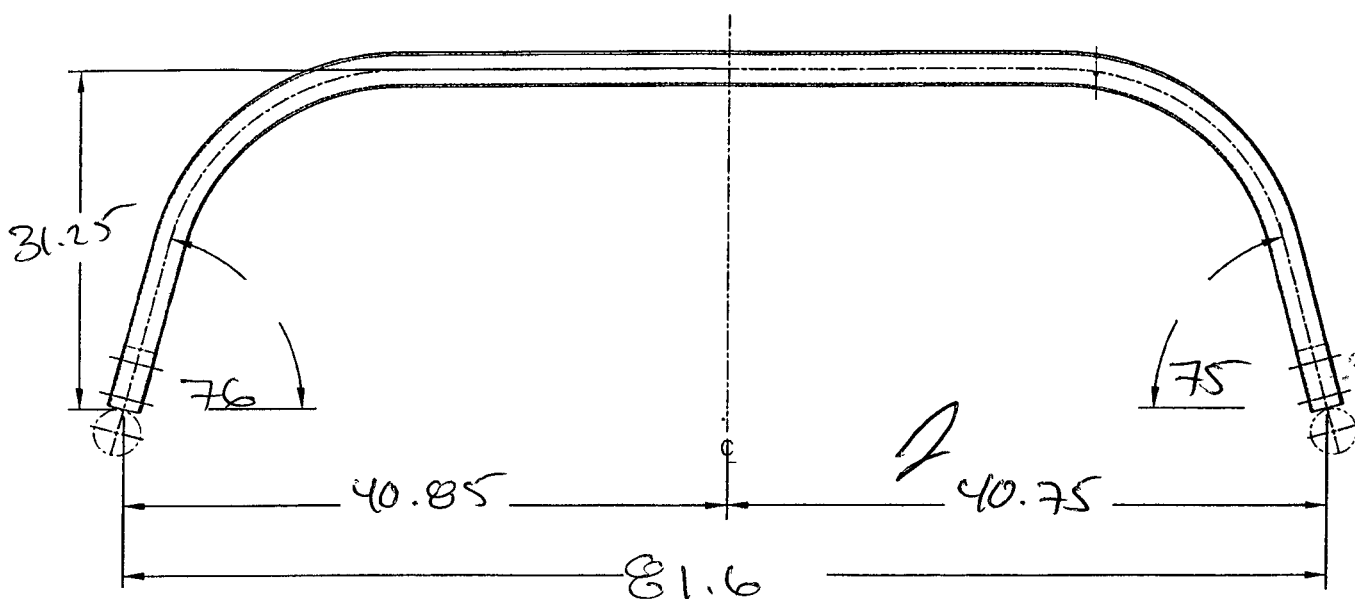
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.236	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.274	✓			
	2.299	+0.005/-0.000	2.300	✓			
	0.063	+/-0.010	.063	✓			
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	.500	✓			
SIDE B	2.240	+0.005/-0.000	2.242	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.236	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.274	✓			
	2.299	+0.005/-0.000	2.300	✓			
	0.063	+/-0.010	.063	✓			
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	.500	✓			
	122.70	+/-0.060	122.70	✓			

Measured by:	J.B.	Audited by:	JB	Prototype Approval:	N/A
Date:	07/04/20	Date:	07/04/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

DART AEROSPACE LTD		Work Order:	31909A
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
Length is slightly uneven by 0.030"

QC15 Inspection	201012
Date	0707-11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

DART**RELEASED**06.10.31 *HH*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

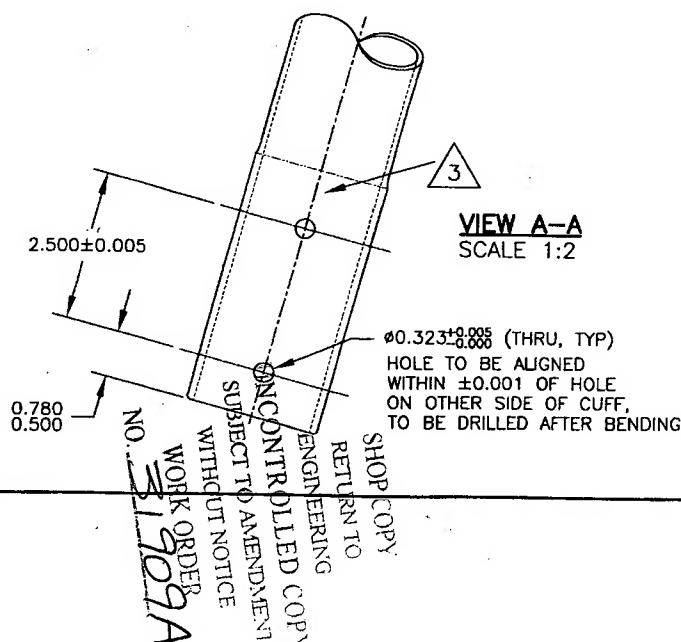
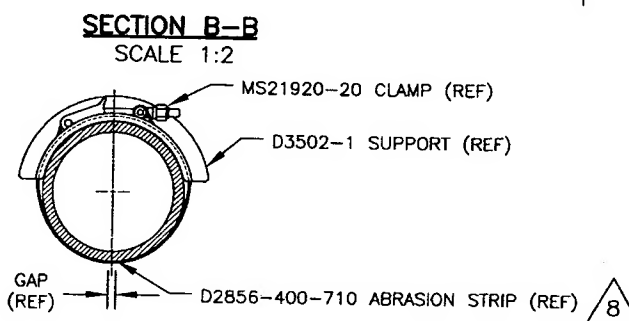
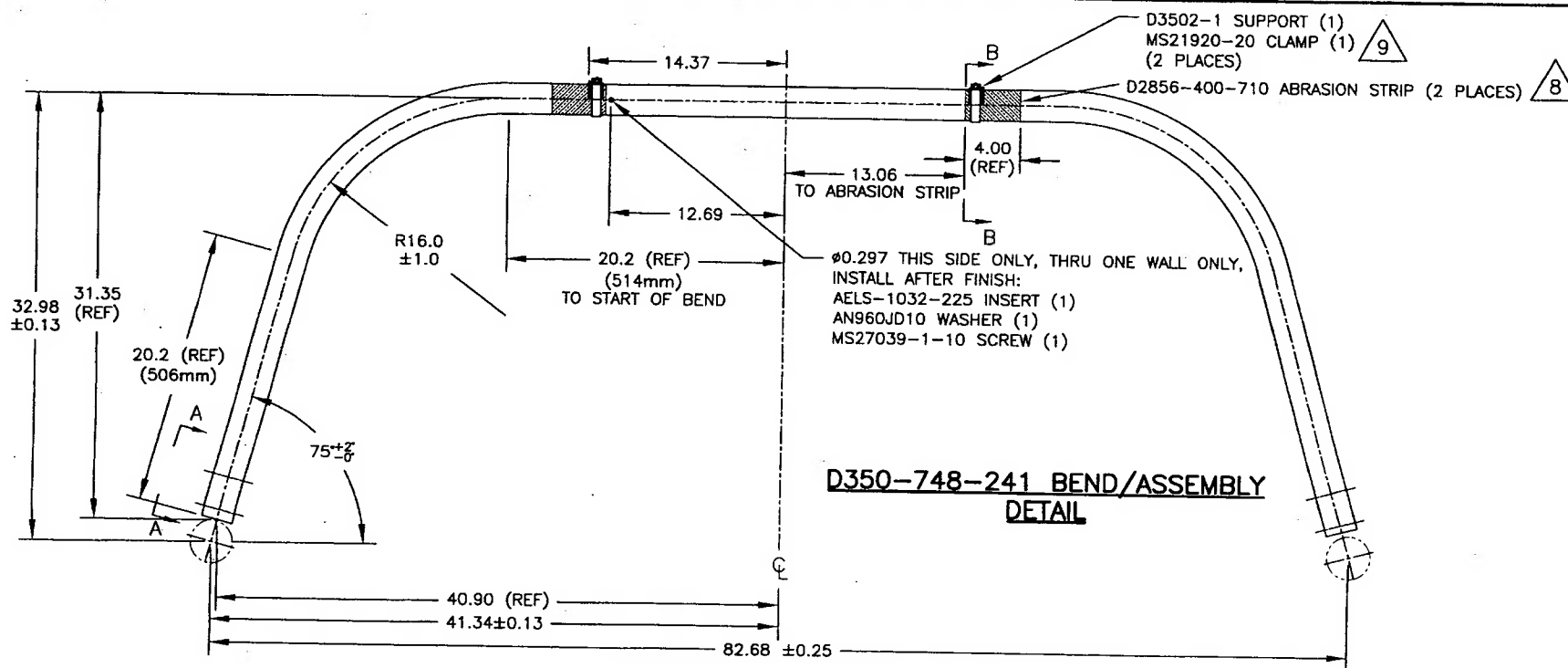
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

UNDER REVIEW07.02.16 *HH*
CUFF BEING REDUCED

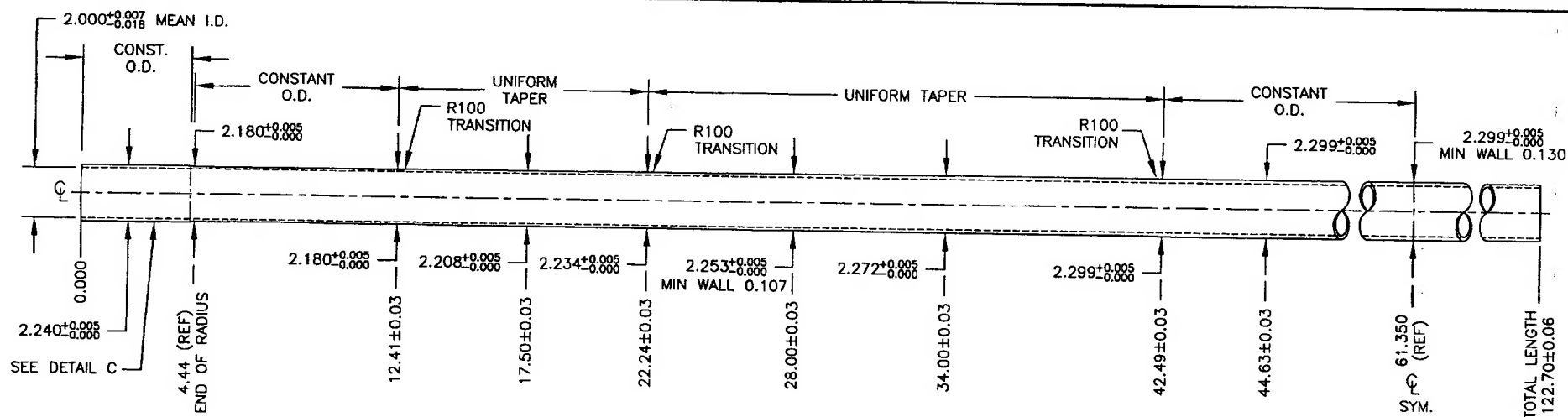
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07.04.18
UNDER REVIEW
07.12.16
RELEASED
06.10.31

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		DATE		DRAWING NO.	REV. D
		06.10.31		D350-748-241	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE (AS 350/355 HI AFT)	1:8



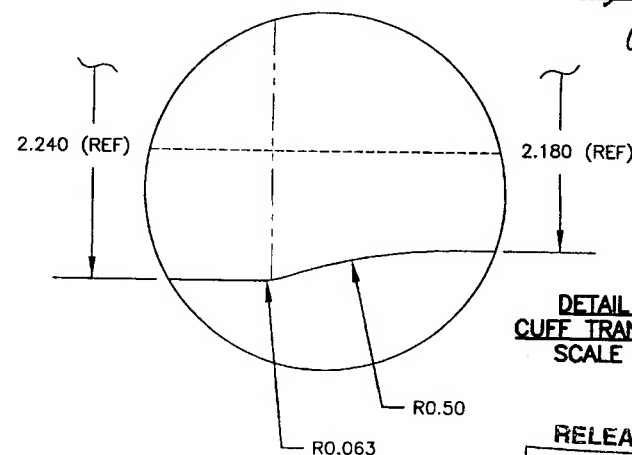
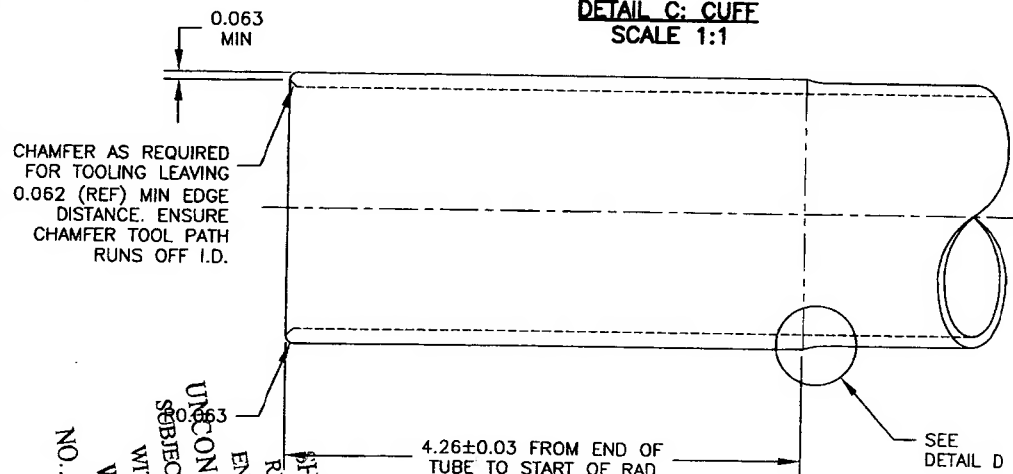
D350-748-241 MACHINING DETAIL

UNDER REVIEW

07.10.16

07.10.16

DETAIL C: CUFF SCALE 1:1



DETAIL D: CUFF TRANSITION SCALE 9:1

RELEASED

06.10.31

NO. 317094
WORK ORDER
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				DATE	06.10.31			TITLE	CROSSTUBE (AS 350/355 HI AFT)
								SCALE	1:4

REV. 0

SHEET 3 OF 3

VAC AERO INTERNATIONAL INC.

RELEASE NOTE

GST No. : R105468102

OAK 87500-1

05/29/2007

MM/DD/YYYY

PAGE : 1

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO : DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
05/29/2007	EPIC 4300450343	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3777 ✓		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141, 241	EA	10	10	
Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS CHECKED AS PER ASTM E-18 HRC 40-43 MATERIAL: 4130 SAND BLASTED P/S# 59141 6 PIECES P/N D350-748-141, S/N B31901A, B31902A, B31903A, B31904A, B31905A, B31906A 4 PIECES P/N D350-748-241, S/N B31907A, B31908A, B31909A, B31910A					
NOTE: NO SERIAL NUMBERS FOUND ON PARTS					

100% HARDNESS TESTED

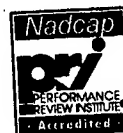
10 pcs → 42/43 HRC

V.A.I.O.
T.M.
27
Q.C.

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



HEAT
TREATING



SPECIAL PROCESSING FURNACE EQUIPMENT

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Aug-13-2007

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St
Hawksbury, ON K6A 1K7

W/O #: 68802

INVOICE #: 35484

**CONTRACT OR
PURCHASE ORDER #**

4203

DESCRIPTION: SKID

QTY 1

P/N # D350748241

S/N # B31909A7

**CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1 MPI IAW
ASTM-E-1444 AND ACCEPTED BAKE HEAT CHARTS #8066 & 8136**

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:

Ray Last

R. LAST

